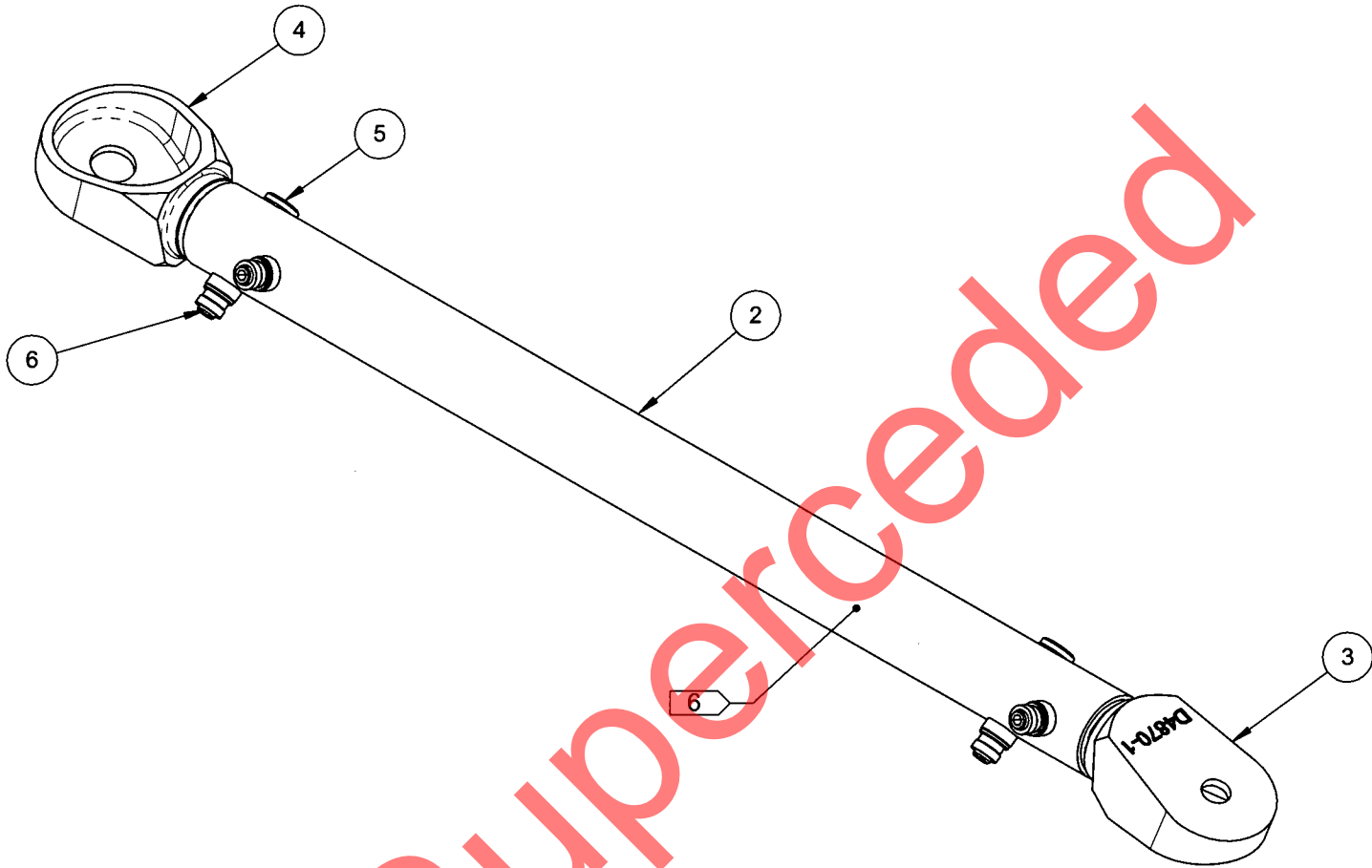


ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4866-041	LEG ASSEMBLY, AFT
2	1	D4866-1	STRUT
3	1	D4870-1	END FITTING, SMALL
4	1	D4870-3	END FITTING, LARGE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4866-041 LEG ASSEMBLY, AFT  
(EQUIVALENT TO BELL P/N 206-063-105-001)

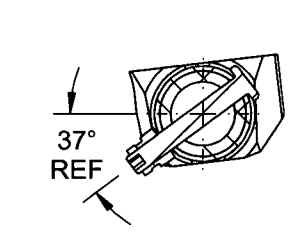
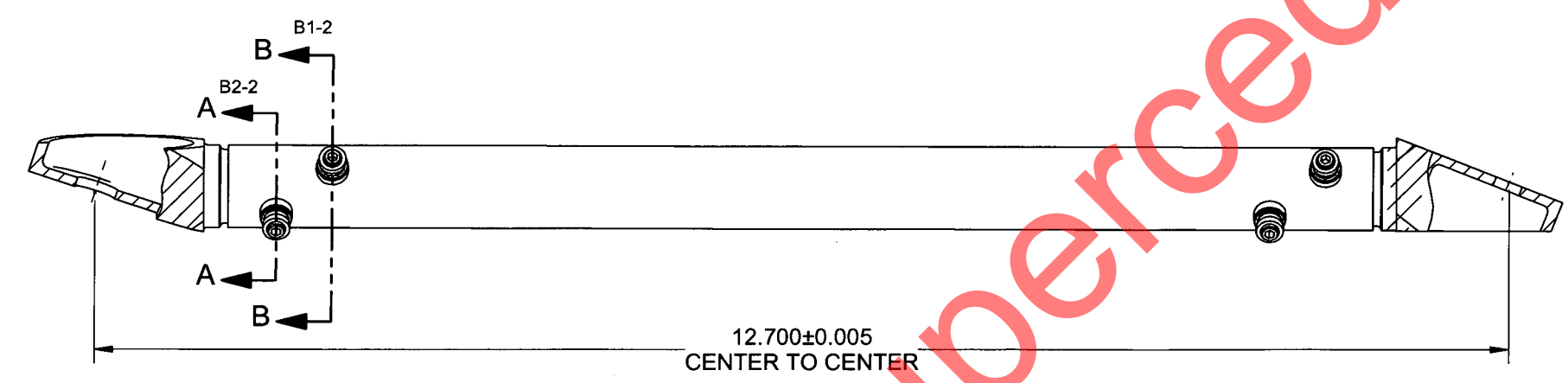
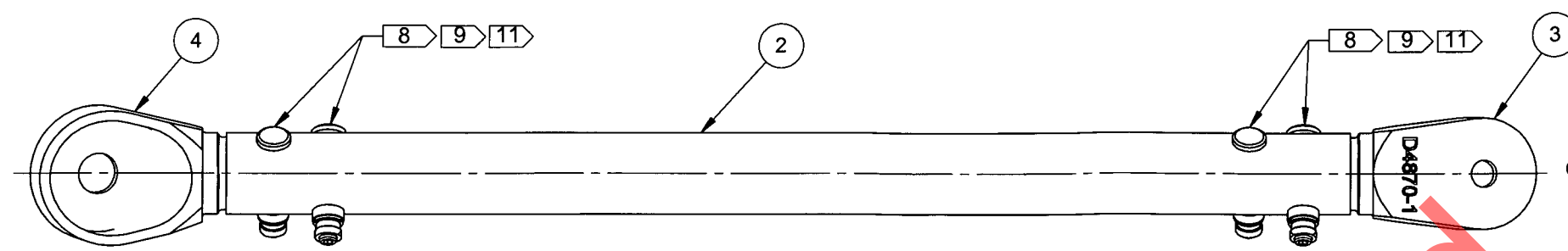
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2014-06-16  
*MP*

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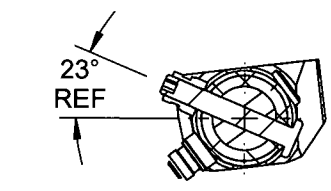
- 1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8  
7) WEIGHT: 0.76 lbs  
8) ALIGN PILOT HOLES IN D4866-1 WITH PILOT HOLES IN D4870-1 & D4870-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9962  
9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET  
10) ASSEMBLE PER DART TOOL DT9962  
11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED

B	REVISE NOTES 6) & 9) (ZN A8-1, A8-3); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4866	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.04.08	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**SECTION A-A** C7-2  
2 PL



**SECTION B-B** C7-2  
2 PL

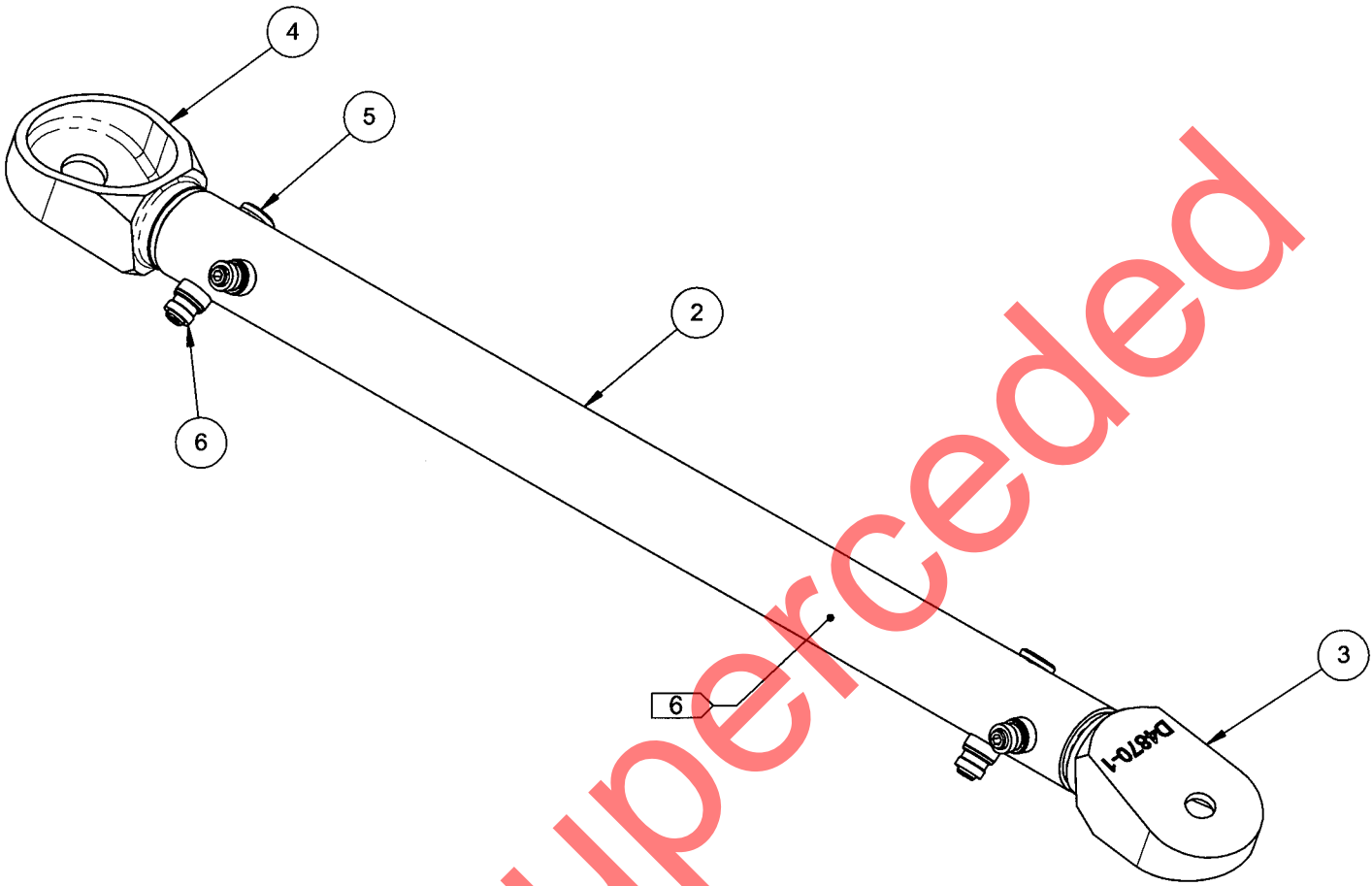
**D4866-041 LEG ASSEMBLY, AFT**  
AUXILIARY VIEW

**RELEASED**  
2014 -06- 16

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. <b>D4866</b>	REV. B
MFG. APPR.	JLM		SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4866-042	LEG ASSEMBLY, AFT
2	1	D4866-2	STRUT
3	1	D4870-1	END FITTING, SMALL
4	1	D4870-3	END FITTING, LARGE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4866-042 LEG ASSEMBLY, AFT  
(EQUIVALENT TO BELL P/N 206-063-105-002)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
  - 7) WEIGHT: 0.76 lbs
  - 8) ALIGN PILOT HOLES IN D4866-2 WITH PILOT HOLES IN D4870-1 & D4870-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9963
  - 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
  - 10) ASSEMBLE PER DART TOOL DT9963
  - 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

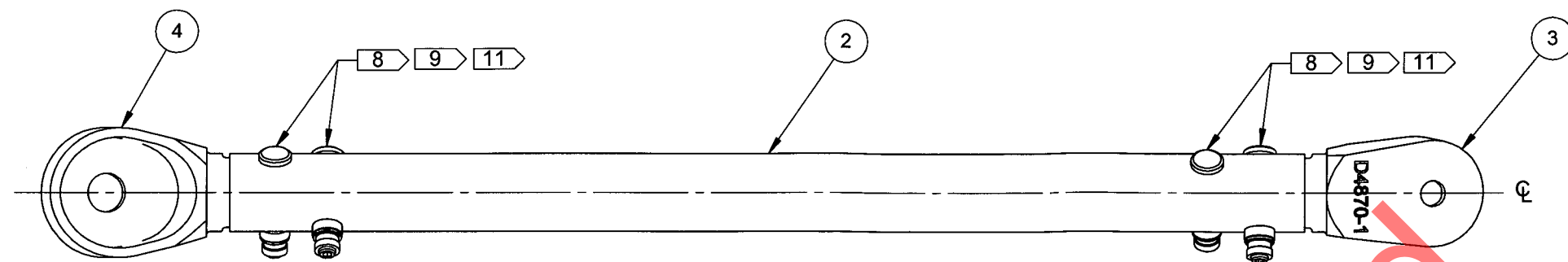
RELEASED  
2014 -06- 16

APPROVED

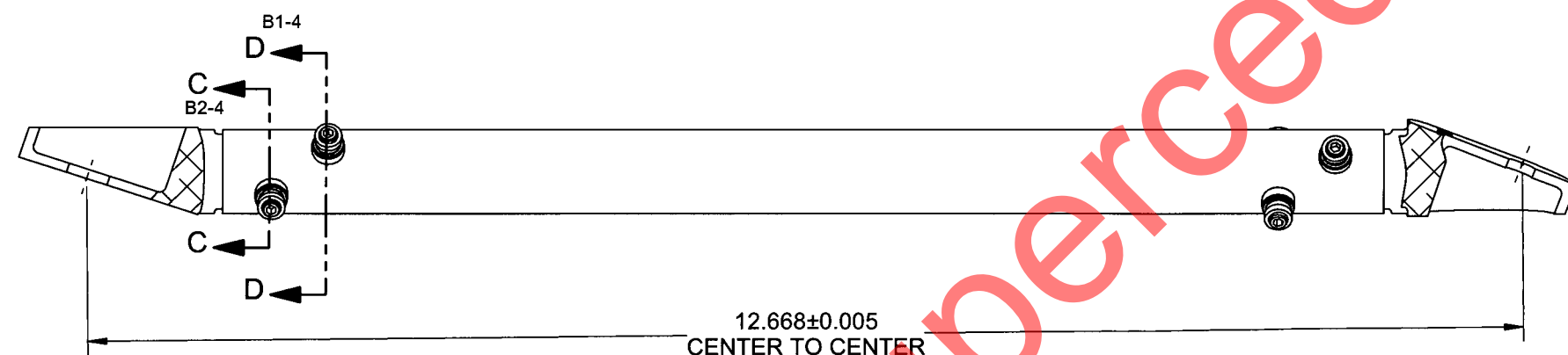
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4866	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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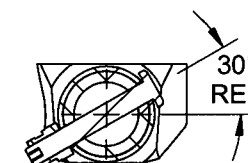
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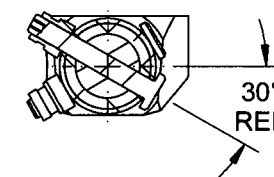
C



B



**SECTION C-C** C7-4  
2 PL



**SECTION D-D** C7-4  
2 PL

**D4866-042 LEG ASSEMBLY, AFT**  
AUXILIARY VIEW

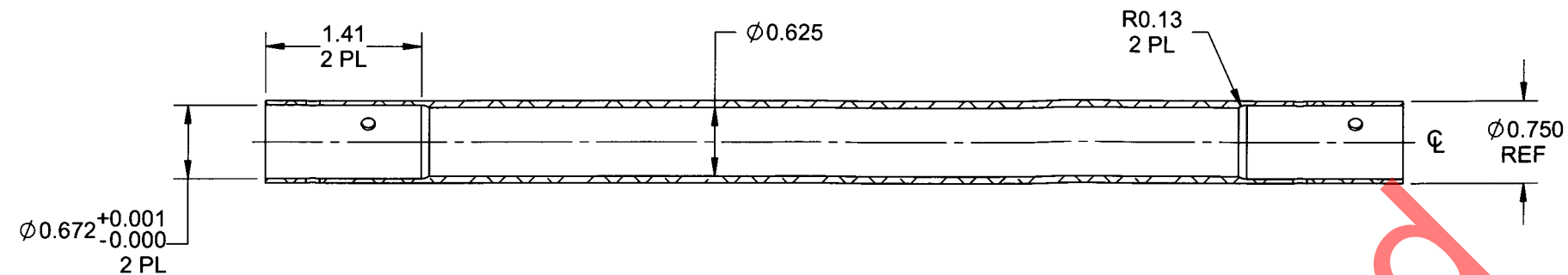
**RELEASED**  
2014-06-16  
*mp*

A

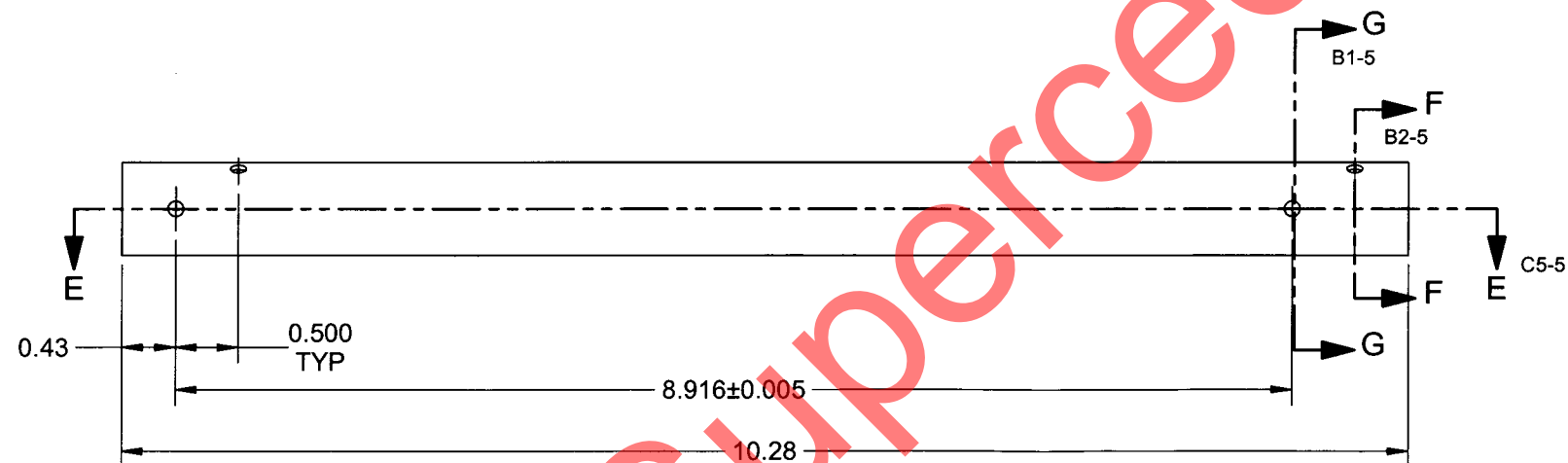
APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. <b>D4866</b>	REV. B
MFG. APPR.	JLM		SHEET 4 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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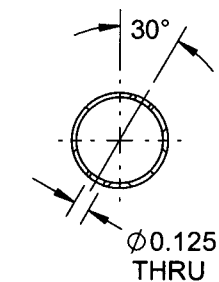
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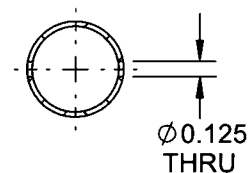
**SECTION E-E** B3-5



**D4866-1 STRUT**



**SECTION F-F** C4-5  
2 PL



**SECTION G-G** C4-5  
2 PL

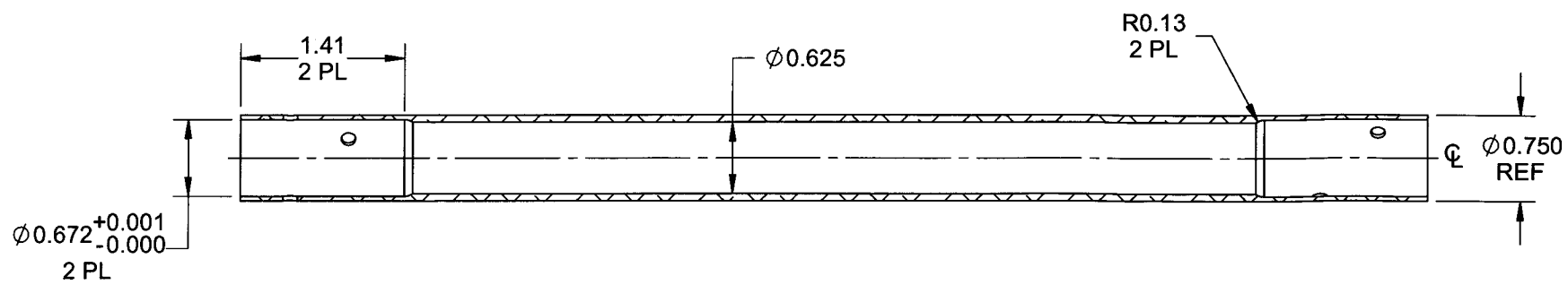
**NOTES:**

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.36 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

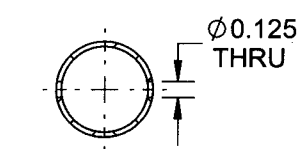
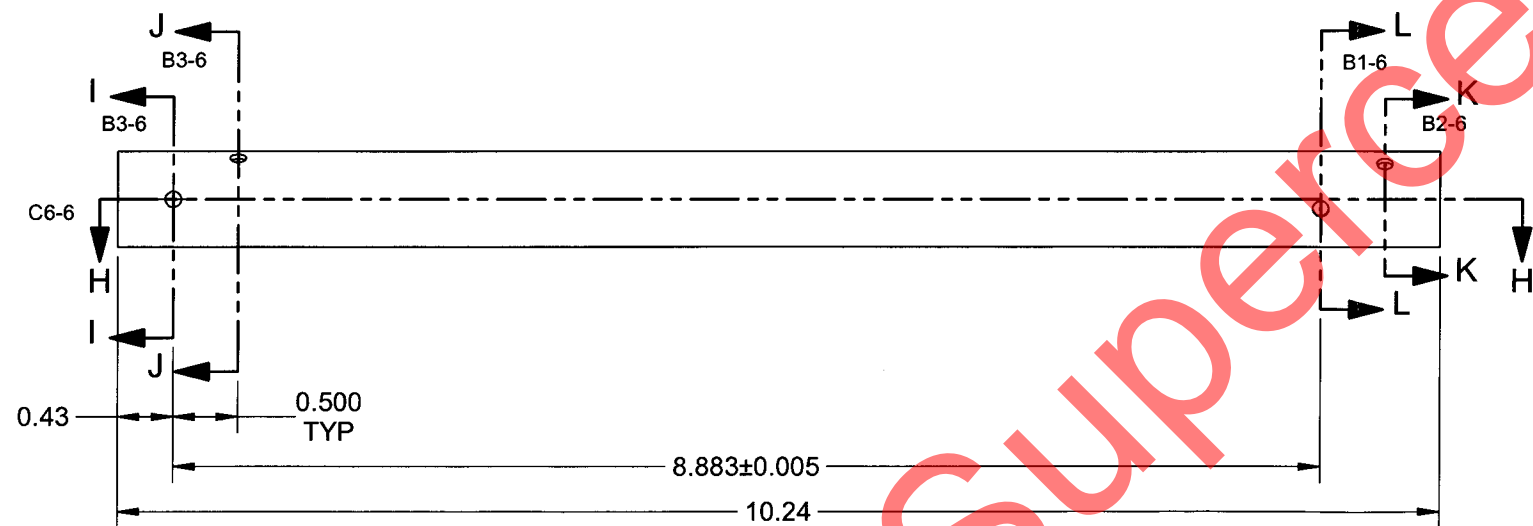
APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. <b>D4866</b>	REV. B
MFG. APPR.	JLM	SHEET 5 OF 6	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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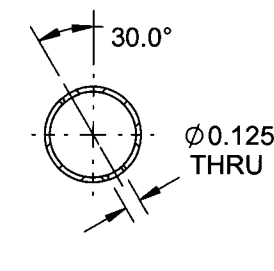
**RELEASED**  
2014-06-16  
*[Signature]*



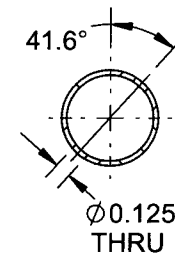
**SECTION H-H B8-6**



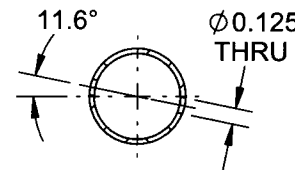
**SECTION I-I C8-6**



**SECTION J-J C7-6**



**SECTION K-K C4-6**



**SECTION L-L C5-6**

**D4866-2 STRUT**

**NOTES:**

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

**RELEASED**  
2014-06-16  
*MP*

APPROVED

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. <b>D4866</b>	REV. B
MFG. APPR.	JLM	SHEET 6 OF 6	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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